

Case 2099

**ART 34 AMDT.**AMENDED CLAIMS

1. Method of manufacturing at least one device (2, 30, 48) defining a volume (8) for retaining a fluid or a sensitive material that is capable of changing its physical properties, particularly its optical properties, via the application of a voltage, or its electrical properties via stress or radiation, said device (2, 30, 48) including at least a first front substrate (4, 38, 56) and at least a second back substrate (6, 32, 50) maintained at a constant distance from each other, these two substrates (6, 32, 50; 4, 38, 56) being joined by a sealing joint (24, 46, 72) which defines the volume (8) for retaining the sensitive medium or fluid,  
said method being characterised in that it includes the steps of:
  - structuring at least one wall (12, 44, 66), which defines via its inner lateral face the volume (8) for retaining the sensitive medium or fluid, on one of the substrates (6, 32, 50);
  - joining the second substrate (4, 38, 56) to the first substrate (6, 32, 50);
  - introducing a sealing material capable of flowing into the gap (22) defined by the outer lateral face of the wall (12, 44, 66) and the two superposed substrates (6, 32, 50; 4, 38, 56) until at least a part of the volume of said gap (22) is occupied by the sealing material, and
  - solidifying the sealing material so that the latter forms the sealing frame (26, 46, 72).
2. Method according to claim 1, characterised in that it includes the steps of:
  - structuring, on one of the substrates (6, 32, 50), at least one filling channel (22) defined by two walls (10, 12), which extend at a distance from each other;
  - joining the second substrate (4, 38, 56) to the first substrate (6, 32, 50);
  - introducing a sealing material capable of flowing into the filling channel (20) until the entire volume of said filling channel (20) is occupied, and
  - solidifying the sealing material so that the latter forms the sealing joint (26, 46, 72).
3. Method according to claim 2, characterised in that a batch of devices (2, 30, 48) is made including two plates (74, 6) common to all of the devices and a network of sealed walls (10, 12) defining, for each device, a volume (8) for retaining the sensitive medium or fluid as well as the filling channels (20) which are to be filled

with a sealing material to connect the two plates (74, 76) and to form the sealing joints of said devices.

4. Method according to claim 3, characterised in that a first plurality of holes (16) for filling the volumes (8) with the fluid or sensitive material, and a second  
5 plurality of holes (18) for feeding the sealing material, are made in one of the plates (74, 76).

5. Method according to any of claims 3 or 4, characterised in that one filling channel (20) is shared by at least two adjacent devices.

6. Method according to any of claims 1 to 5, characterised in that the  
10 sealing material penetrates the gap (22) by capillary action.

7. Method according to any of claims 2 to 5, characterised in that the sealing material penetrates the filling channels (20) by capillary action.

8. Method according to claim 7, characterised in that it includes the additional steps of:

15 - creating a vacuum in the filling channel (20);  
- causing the sealing material to enter said filling channel (20), and  
- re-establishing the pressure outside the cell (2, 30, 48) such that, via the pressure difference between the filling channel (20) in which the vacuum prevails and the ambient pressure, the sealing material is driven to the bottom of the filling  
20 channel (20).

9. Method according to any of claims 1 to 8, characterised in that a layer of photoresist material, which will subsequently be structured by photo-etching techniques to give it the shape of one or several walls (10, 12; 44, 66), is deposited on one of the substrates (6, 32, 50).

25 10. Method according to claim 9, characterised in that the photoresist layer is structured so as to form, not only the wall or walls (12, 12), but also spacer structures (14) for maintaining a constant distance between the two substrates (4, 6) of the cell (2).

11. Method according to any of claims 1 to 8, characterised in that the wall or  
30 walls (10, 12; 44, 66) are structured by a selective technique for depositing the sealing material.

12. Method according to claim 11, characterised in that the wall or walls (10, 12; 44, 66) are structured by screen printing.

13. Method according to claim 11, characterised in that the wall or walls (10,  
35 12; 44, 66) are structured by means of a syringe type dispenser.

14. Method according to any of claims 1 to 13, characterised in that the sealing material is selected from the group formed by resins that can be polymerised

by sensitisation using a light or by heating by raising the temperature of the ambient medium, by cyanoacrylate adhesives, by thermoplastic resins and by dual component adhesives whose components harden over time or via a rise in temperature when they are placed in each other's presence.

5           15. Device (2, 30, 48) defining a volume (8) for confining a fluid or sensitive material capable of changing its physical properties, particularly its optical properties, via the application of a voltage, or its electrical properties, via stress or radiation, said device (2, 30, 48) including at least a first front substrate (4, 38, 56) and at least a  
10           second back substrate (6, 32, 50) maintained at a constant distance from each other, these two substrates (6, 32, 50; 4, 38, 56) being joined by a sealing joint (24, 46, 72) which defines the volume (8) for retaining the sensitive medium or fluid, the sealing joint (26, 46, 72) at least partly occupying the gap defined by said substrates and the outer lateral face of a wall (12, 44, 66) structured on one of the substrates (4, 38, 56), said wall defining by its inner lateral face the volume (8) for retaining the sensitive  
15           material or fluid, said device being characterised in that the sealing joint (24, 46, 72) is in contact on one side with the external face of the wall (12, 44, 66) and on another side with the external atmosphere.

          16. Device (2, 30, 48) defining a volume (8) for confining a fluid or sensitive material capable of changing its physical properties, particularly its optical properties,  
20           via the application of a voltage, or its electrical properties, via stress or radiation, said device (2, 30, 48) including at least a first front substrate (4, 38, 56) and at least a second back substrate (6, 32, 50) maintained at a constant distance from each other, these two substrates (6, 32, 50; 4, 38, 56) being joined by a sealing joint (24, 46, 72) which defines the volume (8) for retaining the sensitive medium or fluid, the sealing  
25           joint (26, 46, 72) being formed by a filling channel (20) defined by two walls (10, 12) which extend at a distance from each other over the substrate (6) on which said walls are formed, said filling channel (20) being intended to be filled with a sealing material, said device being characterised in that at least one hole (18) communicating with the filling channel (20) and for feeding the sealing material is made in one of the  
30           substrates (4, 6) or in the wall (10).

          17. Device according to any of claims 14 to 16, characterised in that it forms an electro-optical cell, particularly a liquid crystal cell, an electrochemical photovoltaic cell or a fluidic type micro-system.